

Shp 29/04

Dart Aerospace Ltd.

Date: Wednesday, 23/04/2008 7:02:34 AM  
User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SUPPORT BRACKET
<b>Job Number</b> : 38766	
<b>Estimate Number</b> : 10260	
<b>P.O. Number</b> :	<b>Part Number</b> : D23623
<b>This Issue</b> : 23/04/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2362 REV E1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : E1
<b>Previous Run</b> : 37459	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 29/04/2008 <b>Qty:</b> 8 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est: G 00.05.18 Added inspection level 8 EC	

### Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D2265	Step Bracket
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Step Support  
Pick:

Qty	Part Number	Description	Batch
1	D2265	Step Support	37477

Ind 2.04.25 (8)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** Machine per folio D2362-3

EC 08.04.28 8

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** Inspect Level 2

EC 08.04.28 8

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

Ind 08/04/28 (8)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr

EC 08.04.28 38766

6.0	POWDER COATING	POWDER COATING
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**Comment:** POWDER COATING

Powder Coat Gloss White (Ref 4.3.5.1) as per Dart QSI 005 4.3

Ind 08.04.28 (X)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 23/04/2008 7:02:34 AM  
Usér: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 38766

Part Number: D23623

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

BR 08-04-28

②

8.0

D23971

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-1

Rubber

B38053 (12)

B36117 (7x)

SP 08/04/29

9.0

D23973

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-3

Rubber

B36118 (7x)

B38054 (12)

SP 08/04/29

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement  
as per Dwg D2362

Batch M107860

SP 08/04/29

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 08/04/29

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 478

8/4/29

SP

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/29

Job Completion



MF 08-04-29

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**



RELEASED  
98.12.14 KE

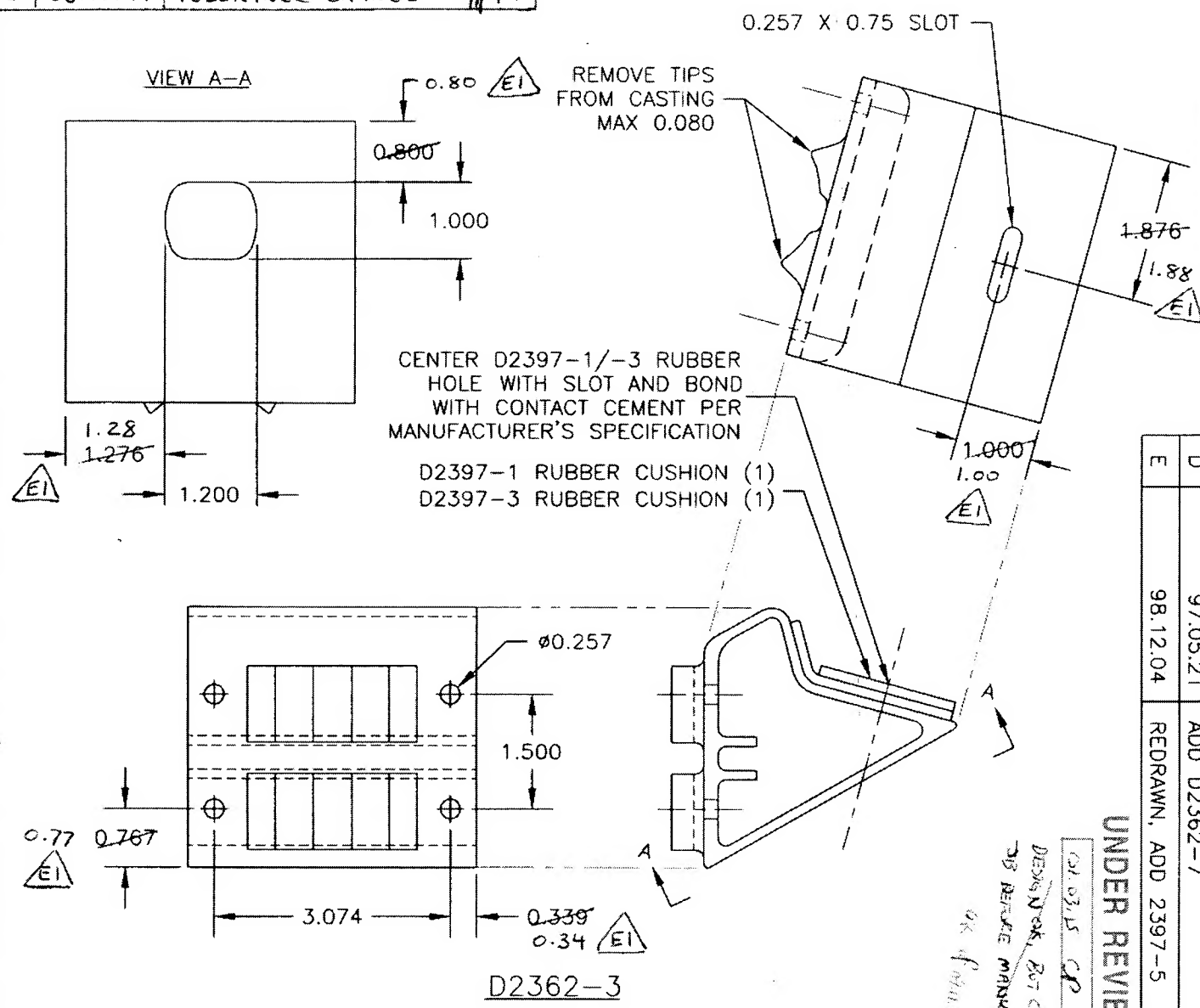
DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. E
BW	CP		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 3
KE	KE	D2362	SCALE
DATE	TITLE	STEP SUPPORT BRACKET	1:2
98.12.04	A	NEW ISSUE	
	B	CHANGED RUBBER TO D2397	
	C	ADD D2362-5	
	D	ADD D2362-7	
	E	REDRAWN, ADD 2397-5	

UNDER REVIEW

01.03.15 CP

DESIGN OK, BUT CHECK WITH  
DUB REMOTE MANUFACTURE  
OK if required

EI 03.10.07 TOLERANCE CHANGE ~~RT~~



NOTES:  
MAKE FROM D2265  
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING RUBBER IN PLACE  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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**DART**

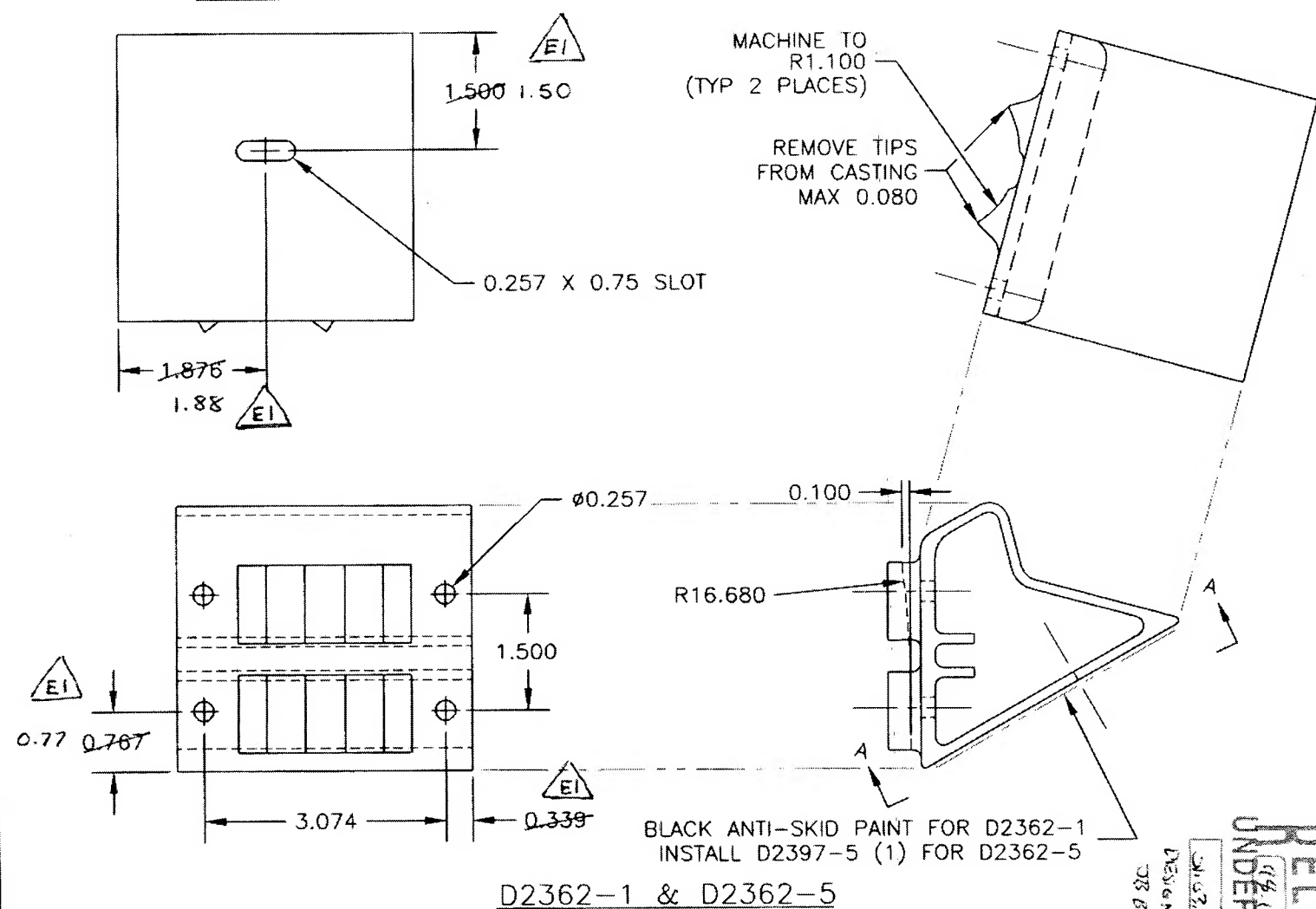


DESIGN	DRAWN BY	DART AEROSPACE LTD	
BW	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
KE	JB	D2362	SHEET 2 OF 3
DATE	TITLE	SCALE	
98.12.04	STEP SUPPORT BRACKET	1:2	

**RELEASED**  
14.12.14  
UNDER REVIEW

DESIGNED BY: CP  
08 BENTON/MAINT FACTORY

VIEW A-A



**NOTES:**  
 MAKE FROM D2265  
 D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4  
 D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION  
 FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3  
 BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

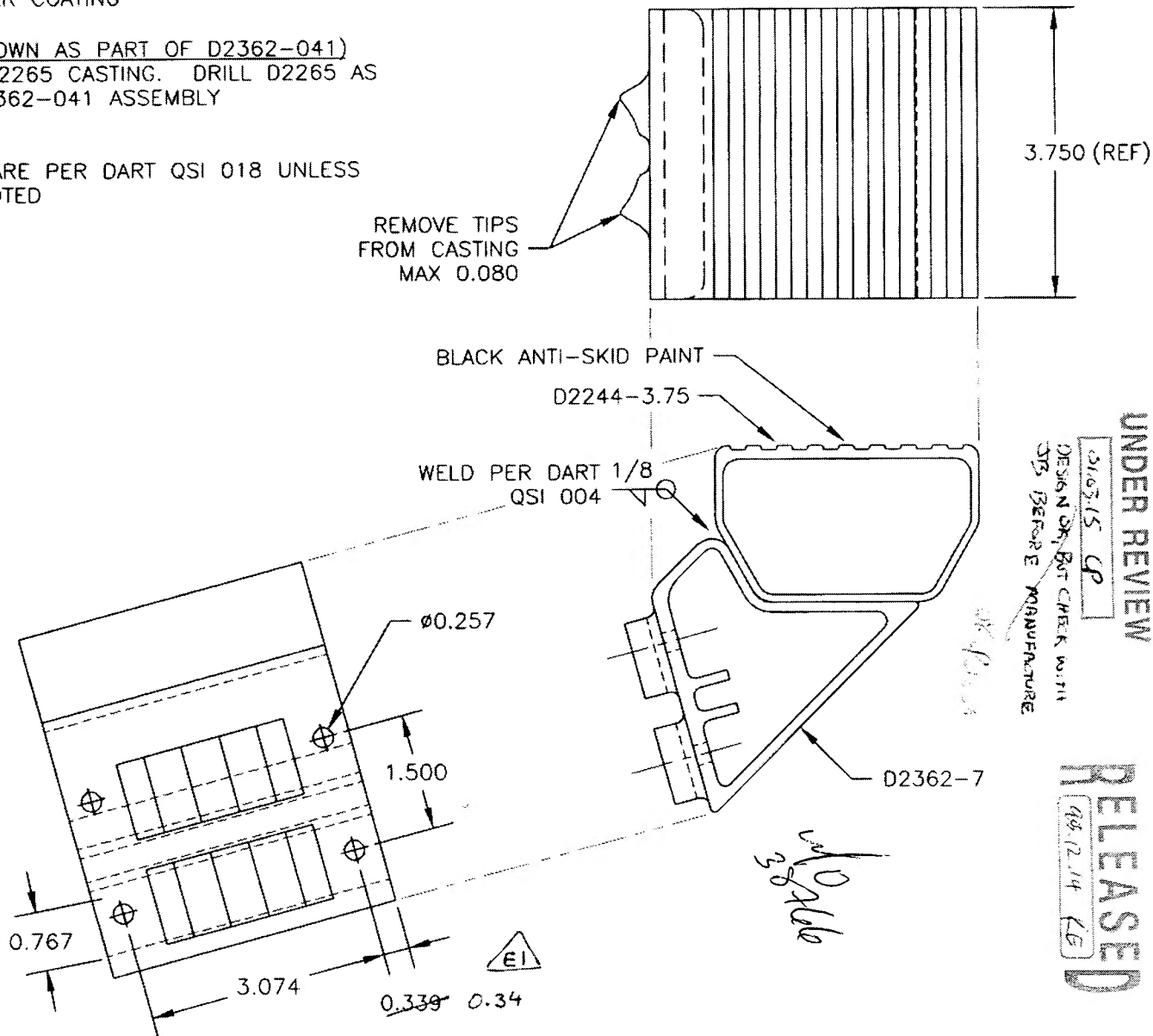
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FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER  
QSI 005 4.3  
ANTI-SKID PIAINT PER QSI 005 4.4 AFTER  
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)  
MAKE FROM D2265 CASTING. DRILL D2265 AS  
SHOWN IN D2362-041 ASSEMBLY

NOTES:  
TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED



# DART



DESIGN	DRAWING BY		DARI AEROSPACE LIB	
BW			HAMKESBURT, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E	
<i>KE</i>	<i>HA</i>	D2362	SHEET 3 OF 3	
DATE	TITLE		SCALE	
98.12.04	STEP SUPPORT BRACKET		1:2	

# UNDER REVIEW

98-12-14 KE

0105/15 CP  
DESIGN OK, BUT CHECK WITH  
JTS BEFORE MANUFACTURE

Copyright 1995 by DART AEROSPACE LTD

[illegible]



DART Aerospace Ltd

#R08-50

## CUSTOMER RETURN

Initiator: Jan Kerr  
 Company: Worldwide Maint.  
CWORLD  
 Phone No. 425-793-8400

Date: May 9/08  
 Invoice # 6443  
 Order Entry # 5934

Attach Copy of DHS Return Authorization # 401

Reason for return: Customer - M's order understood Catalogue  
ordered correct Bracket.

Receiving: AO  
 Date Received: 8/8/23 Freight Company: FedEx Ground Prepaid Collect

#	Part #	Batch #	Description	Distribute to QC	
				Advise QA	Date:
4	D2362-3	38766	Step Support Bracket	<u>DAVE</u>	<u>8/8/23</u>

Condition of packaging: Good Photograph required: yes ☒ no

Paperwork attached: P/S ☒ Invoice ☐ ARC ☐ Docs ☐ Other ☐

## QC:

Quarantine: Location:   Condition of Part: good

Inspect: Initial:  

#	Part #	Batch #	QC Comments	QC Approval		Scrap
				Initial	W/O #	
4	D2362-3	38766	Return to stock as per WO	<u> </u>	<u>39471</u>	

## QA Coordinator:

Advise GM as to findings: Initial:   Date:  

Comments:

Issue credit: yes no

GM Approval:   Date:  

Invoice Amount:    
 Less Replacement:    
 Restock Fee:    
 Freight:    
 Net Credit:    
 DHS ☐ Customer ☐

QA: Enter into Q-Pulse with reason for return & File original. Signed:   Date:  

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit